

SOUTH PRODUCTION NOTES

**December 26, 2013
Afternoon Shift**

**BASF EMPLOYEES
34 Last Recordable
179 Last Lost Time**

#1 MED AL-5637: No longer making batches of AL-5637. The plan is to use the dryer and calciner for D-0756. We need to do a very good clean up of the dryer/spiral and calciner. We will go back to the AL-5637 when we are done running the D-0756.

#1 RC / clean for D-0756: We brought the temperatures down and reversed the calciner. The calciner needs cleaned for the D-0756 material. We will use cone totes and feed through the floor.

Exhaust to Trimer

Midnight Shift: Put screener together. Continued cleaning spiral. Needs cleaned out at bottom of spiral and bolted back together.

Day shift: Spirals cleaned, dryer touched up, auto sampler cleaned out, cone totes washed out, P&S hard pipe discharge rinsed out. Need to walk through whole system from P&S to the calciner discharge, button up and feed 500 lbs silica sand through the system from P&S to the calciner discharge. Scheduled for afternoon. Final inspection then needed (Friday morning) and if OK, will begin lighting dryer and calciner.

Afternoon Shift:

#2 MED line/ D-0768: Continue/ Continue hand-picking contaminated bagged material...feed this material to the calciner hopper when possible. 1 bag remaining.

Midnight Shift: Continued.

Day Shift: Continue on. Grodecki advised that we will continue until either the microorb or the copper carbonate runs out.

Afternoon Shift:

#2 RC/ D-0768: When we reach the end of lot EL00231 SS 10 we will need to switch to drums. There are blue drums in the rail shed that need to be used for this. Also, be sure to shovel the material from the floor onto the dryer bed on the feed end of the dryer at least once a shift. Continue to feed the calciner and check the screen on the granulator once a day to make sure there is not a hole in it. **SAMPLING NOTE:** when we switch to drums, please get two 16 oz samples per pallet for the lab.

Midnight Shift: Filling drums/ Ran out of feed/2 bags on floor now.

Day shift: Continue on, feed calciner as material is available. Granulator screen was checked and not worn out, but screen was loose. Re-tightened and running OK.

Afternoon Shift:

Exhaust to CTO

#3 MED line /Next D-1795 NAQ: Continue following the clean up sheet and signing off on what you have completed. The dryer/spiral/calcliner/and calcliner spiral should be done before the mixer/pulva/extruder. We will need to wash out the calciner and clean the spiral elevators before running.

Midnight Shift: No change.

Day shift: No change. Set-up instructions for the D 1795 will (through dryer) will be provided by Grodecki on Friday.

Afternoon Shift:

#3 RC /Next D-1795 NAQ: We will need to wash out the calciner and clean the spiral elevators before running.

Exhaust to CTO

Midnight shift: No change.

Day shift: Calcliner re-assembled. Will discuss whether to run flush or sand through on Friday with Grodecki.

Afternoon Shift:

Abbe Blender / D-5206: Continue on until we are out of HF. We should have 24 batches left as of 3PM Friday the 20th. All of the 5202 should be in the railshed.

Midnight shift: Out of HF.

Day shift: No change.

Afternoon Shift: Officially out of HF.

National Dryer / 5206 : Many bags of wet material will need to be refed before we feed them to the calciner.

Midnight shift: No feed.

Day shift: No feed.

Afternoon Shift:

#4 RC / D-5206: Concrete work has been completed. Start calciner as manpower permits(need floor CRT to walk the line prior to restart.)

Exhaust to 4 DC

Midnight shift: Continued.

Day shift: Continue on

Afternoon Shift:

HC-11 Tanks / Cu 5020: Continue on. There is a pallet of Britesorb samples that were returned to the department (HC-11). At least one box contains 1 gallon (4 lb) pails. Per Noemi Trent, please add one of these to each strike batch in 4 tank.
Midnight shift: Pump on Tank 107 is not working-work order is in.
Day shift: 107 tank pump was inspected and OK, bottom of tank had some blockage. Blockage was cleared and batch was sent to copper mid shift, but having trouble filtering. Taking tank level down low before taking next strike. Should be able to receive next strike early afternoon shift.
Afternoon Shift:

PK Blender / 4011: 19 batches of 4011 completed. On hold for now.
Midnight shift: No change
Day shift: No change.
Afternoon Shift: No change.

#5 RC / 4011 done. DC has new HEPA filter installed.
Exhaust to Trimer
Midnight shift: Down
Day shift: Down
Afternoon Shift:

New Pfaudler / BE-0101: Continue on when batches needed. Stay in contact with the tunnel kilns to see when material is needed. Batch 32 will be the last batch.
Midnight shift: Hold until day shift
Day shift: Batch 32 made, rinsing pfaudler for Friday morning as we will be making next batches using Al 3921 E 1/8th batches (Lot 3, bags 5-7, 9-14, extrusions vs tablets), per Justin Quach. Hold until then.
Afternoon Shift:

Old Pfaudler D-0756: On hold until the sly scrubber can be fixed. Need to use RO unit for batches. PLEASE NOTE that each bag of base must be weighed (check-weigh) before loading into the pfaudler. Need to confirm that the bag weights are correct.
Midnight shift: On Hold.
Day shift: No change. As of early afternoon parts not delivered yet.
Afternoon Shift:

#6 - RC / D-0756: Down due to the sly scrubber blower motor being down. The bags that come off of this calciner need to be check weighed in building 31 and recorded on the log sheet. MAKE SURE THAT WE TAPE SHUT THE SAMPLE JARS. Maintain 250 lbs/hr.

Exhaust to Sly Scrubber

Midnight shift: Down.

Day Shift: Down until sly scrubber is fixed.

Afternoon Shift: On hold. See Day shift note.

Tower 3 / Cu-0860: Loaded and Running. Should come down midnight shift early Friday

Tower 6 / Cu-0860: Loaded and running.

Midnight Shift: Continued.

Day shift: Continue

Afternoon shift:

Harrop Kiln - Al-3921 T 3/16": Down...saggers will need to be changed to half saggers in the near future for next product. Also, parts from the harrop screener were used on the 2nd screener in the tunnel kilns.

North Screener / Cu-0860: Continue/Maintenance repaired Nitrogen leaks on Tuesday.

Midnight shift:Continue....15 totes

Day shift: Continue

Afternoon Shift:

South Screener / Cu-0860: Continue.

Midnight shift: Continue...15 totes

Day shift: Continue

AfternoonShift:

#2662 Pill Machine / Al-3917 3/16: Finished. Holding for decision to switch to 3915.

#2664 Pill Machine / Al-3917 3/16: Finished. Holding for decision to switch to 3915.

Midnight shift: No change

Day shift: No change.

Afternoon Shift: No Change.

Tunnel Kiln #2 / BE-0101: Continue loading/unloading. ..1 scoop per sagger-12 pounds.

Use the cooling water during the venting/cooling phase.

Midnight shift: 2 on floor/1 full hanging.

Day shift: Continue. NOTE: We will be making three special batches of BE 01010 using Al 3921 extrusions starting Friday. When the first batch is made, we will need to run out whatever bag is on TK #2, use an empty car as a spacer, then start loading the new BE 0101 material. In addition, the screener fines screen will need to be changed BEFORE we screen the new material. MOD will be updated, and this information will be discussed further with the TK operators. Currently have 4 full bags on the floor and a “less than full” bag at each kiln.

Afternoon Shift:

Tunnel Kiln #4 / BE-0101: Continue loading/unloading. ..1 scoop per sagger-12 pounds.

Midnight shift: 2 on floor/1 full hanging.

Day shift: Continue. Currently have 4 full bags on the floor and a “less than full” bag at each kiln.

Afternoon Shift:

Bill Grodecki's Instructions:

- I. I have left cleanup instructions for MED3/RC3. The next product on mix/extrusion (starting mid-January) will be similar to D-1794 so only a rough cleanup of mix/extrude is necessary. D-1795 will run on dry/calcline starting ~12/30. Only a rough cleanup is needed to avoid white extrusions in the colored product. Since we have 2 weeks, this is a good fill in job.
- II. SSD is going well but please check the granulator screen daily and change if necessary. Lengths will be off if a hole goes undetected.

Tim and I discussed it and made an executive decision to begin taking department retain samples of finished tower products. Operators will begin taking 6-16 oz. samples of finished product (instead of 3). Set 3 on the post for pickup and keep 3 in the screening room for retain. If a sample turns up missing, we will have the retains to give to the lab. Keep the retains for a month and return to production. I will post the new procedure in the screening room.